

Date: Tuesday, 06/05/2008 10:23:51 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-607-047
Job Number : 39069	
Estimate Number : 10804	
P.O. Number :	Part Number : D350607047
This Issue : 06/05/2008 S.O. No. :	Drawing Number : RTN TO STK -HAI
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 31951	Material :
Written By : _____	Due Date : 13/05/2008 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Blk 39069 CHG001
D350-607-047
2008/05/06

Seq. #:	Machine Or Operation:	Description :
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1.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT BASKET FROM HAI
B 31951 CHG001

2008/05/06

2.0	D350607047	Heli-Utility-Basket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Heli-Utility-Basket

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

- CLEAN COMPLETELY
- STRAIGHTEN OUT MOUNTING BRACKETS
- TOUCH UP IDENTIFIED AREAS WITH WHITE IMRON
- TOUCH UP HANDLE

- RE-DO SIKAFLEX
B *M117809*

EXP. DATE *10/2008*

EB08/05/06

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

2008/05/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 10:23:51 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-607-047

Job Number: 39069

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

RE-INSTALL DART DECAL

D2728-3 B 22553

CHECK ALL BOLTS FOR TIGHTNESS

EB08/05/06 @

6.0

D27283

Dart Logo Label - large



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Placard 200lb

B22553

EB08/05/06 @

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/06 @

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

9.0

D22301

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

New Batch not in comp yet
B38740

AS 08/05/06 @

10.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

B37746

AS 08/05/06 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 10:23:51 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-607-047

Job Number: 39069

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

36749

AS 08/05/06 (K)

12.0

D2732

Rubber Extrusion



Comment: Qty.: 2.0000 f(s)/Unit Total : 2.0000 f(s)

Rubber Extrusion

8x D2732-030 (cut to 3")

Batch:

37632

AS 08/05/06 (K)

13.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143

AS 08/05/06 (K)

14.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

M07534

AS 08/05/06 (K)

15.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch:

M107321

AS 08/05/06 (K)

16.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M107321

AS 08/05/06 (K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 10:23:51 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-607-047

Job Number: 39069

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M106051

JS 08/05/06 (K)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/05/07 (K)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-047 CHG001

Location:

B

0002

8/5/7

SLP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



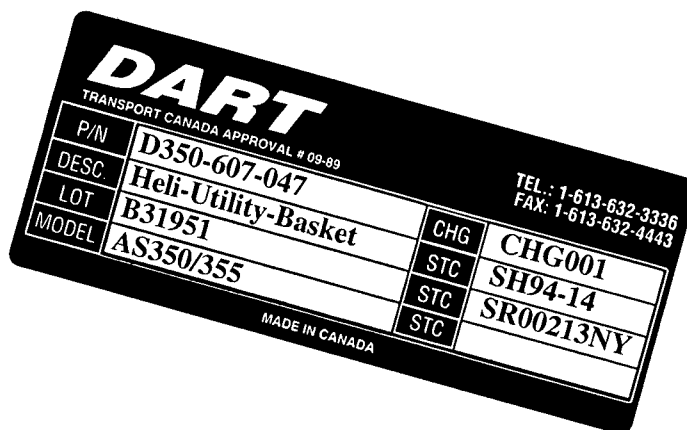
Comment: FINAL INSPECTION/W/O RELEASE

08/05/14

Job Completion



MF 08-05-12



1- Complet clean.

2- Remove Dart Hili-utility Basket Decal.

3- Do touch ups with white Enam Paint

4- ~~Straghten~~ Straghten out Mounting Brackets-

5- Re Do Sikadflex.

B# _____ exp. Date _____

6- Do touch ups on Handle.

7- Reinstall on Dart Decal on Decal Plate. 2288.200

8- Re check all Bolts for tightness.

QC # 5

For

Small

Basket.

00108

90069

Date: Wednesday, 18/04/2007 3:44:47 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-607-047
Job Number : 31951	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D350607047
This Issue : 18/04/2007 S.O. No. : <i>N/A</i>	Drawing Number : RTN TO DTK -HAI
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : <i>N/A</i>
Previous Run : 00015	Material : <i>N/A</i>
Written By : _____	Due Date : 25/04/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
REPACKAGE PER PPP CHG 001 NEW PAPERWORK AND LABELS REQ'D		
3.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



DART
TRANSPORT CANADA APPROVAL # 09-89

P/N	D350-607-047	CHG	CHG001
DESC.	Heli-Utility-Basket	STC	SH94-14
LOT	B21241	STC	SR00213NY
MODEL	AS350/355	STC	

MADE IN CANADA

TEL.: 1-613-632-3336
FAX: 1-613-632-4443

DART AEROSPACE LTD	Work Order:	21241
Description: 350/355 Utility Basket Assembly, LH/RH	Part Number:	D350-607-047
Drawing: D350-607 Rev. F Pages 8,9	Qty:	1
Page 1 of 2		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travellers for: D350-607-047 Utility Basket Ass'y, LH/RH D3265-041 Base D3267-041 Lid Assembly (Outside) D3267-043 Lid Assembly (Inside) Dwg not required	Batch 21241 21241 21241 21241 JH	04.07.13	1
2	DC	Photocopy bluefile and create labels per PPP D350-607-047 CHG001 WK 39 JH	JH	04.09.20	1
3	WS	Go to D3265-041; D3267-041 & D3267-043	PD	04.01.14	1
4	KP	Pick: Assembly Kit Qty Part Number Description Batch 5 D2022-101 Spacer B21505 1 D2258-200 Label B21244 1 D2332-041 Prop Assembly B21547 1 D2530 Handle Weldment B21190 2 D2535 Spring B20827 2 D2537 Bushing B21548 2 D2728-3 Label ✓ 2 D2931 Bumper B21139 2 AN3-16A Bolt m14820 2 AN4-13A Bolt m15928 7 AN4-22A Bolt m13735 4 AN5-17A Bolt m16273 2 AN960JD8 Washer m9636 14 AN960JD416 Washer m15993 2 AN960JD416L Washer m3154 4 AN960JD516 Washer m15927 4 AN970-4 Washer m16504 2 MS20600AD4W3 Rivet m11660 2 MS21042L3 Nut (or -3) m15539 9 MS21042L4 Nut (or -4) m15020 4 MS21042L5 Nut (or -5) m15539 Pick: Packing Kit 4 D2230-1 Lug B21977 4 D2230-3 Clamp B21948 1 *D2324-1 Strut Assembly B21545 4 D2856-400-720 Abrasion Strip B21678 5 AN4-12A Bolt m14940 8 AN4-13A Bolt m15928 26 AN960JD416 Washer m15321 13 MS21042L4 Nut (or -4) m15020 CY 05/01/28 1			
5	GA	Assemble as per Dwg D350-607 Attach Travellers: Qty Part Number Description Batch 1 D3265-041 Base B21241 1 D3267-041 Lid Assembly (Outside) B21241 1 D3267-043 Lid Assembly (Inside) B21241 JB 05/02/01 1			

PR 05-02-2

RELEASED
04.04.08

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	21241
Description: 350/355 Utility Basket Assembly, LH/RH	Part Number:	D350-607-047
Drawing: D350-607 Rev. F Pages 8,9	Qty:	1
Page 2 of 2		

Step	Location	Procedure	By	Date	Qty
6	QC5	Inspect work to Step 5	<i>[Signature]</i>	05/02/01	1
7	QC4	Inspect Kits 100% for completeness on the W/O	<i>[Signature]</i>	05-01-25	1
8	PK	Identify and pack as per PPP D350-607-047 <i>Rev A.</i>	<i>[Signature]</i>	05/02/01	1
9	AC	Cost / part: <u>1575.31</u>	<i>[Signature]</i>	05-02-02	1
10	DC	Close W/Order and Ensure Travelers Attached Inspect Level 21 <u>1575.31</u> Travellers: D350-607-047 D3265-041 D3267-041 D3267-043	<i>[Signature]</i>	05.02.08	1

*Installation instruction refers to D2324. D2324-1 is equivalent.

Rev	Date	Change	Revised By	Approved
A	04.04.06	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
04.04.08 *[Signature]*

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 13, 2004

10:38 am

Work Order No : 0021241
Project Name : D350-607-047
Project For : WK441
Work Order Type : Main
Main WO Number :
House Part Number : *D350-607-047
Description : Heli-Utility-Basket
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 07-13-04
Est Finish Date : 09-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

41

DART AEROSPACE LTD	Work Order:	21241
Description: 350 Basket Base (Short)	Part Number:	D3265-041
Dwg: D3265 Rev. A; D2235 Rev. B1	Qty:	1
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	PD	04.07.13	1
2	WS	Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing. M15360 (M304TS0.750W.065) Batch: M15716 Cut Qty #3 D2235-1 from: Qty #3 D3166-1 Batch: M15483	PD	05-01-14	1
3	WS	Drill hole in D3265-3 as per Dwg D3265	PD	05-01-15	1
4	WS	Deburr	PD	05-01-17	1
5	WS	Pick: Qty Part Number Description Batch 2 D2232-3 Hinge bracket B21247 4 D2325 Support Gusset B21300 2 D2327-3 Bushing B21546 2 D2581 Mounting Bracket B21508 26sf M304EX0.75-16F Expanded Metal M16294 M16510	PD	05-01-24	1
6	WS	Weld as per Dwg D3265 using Welding Table and corner Jig Deburr as required	PD	05-01-24	1
7	QC9/6	Inspect Welding and Dimensions	PD	05/01/24	1
8	WS	Take Traveller D350-607-04X to KP	MM	05/01/24	1
9	FP	Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	MM	05/01/31	1
10	QC3	Inspect Powder Coat	SP	05/02/01	1
11	FP	Seal support gusset seam with White Sikaflex-291 Batch: M16287 Expiry date: 05/09/14	SB	05/02/01	1
12	QC5	Inspect work to Step 11	MM	05/02/01	1
13	FP	To GA Cell for Assembly	CR	05/02/01	1

Rev	Date	Change	Revised By	Approved
A	04.02.02	New issue	KJ/DS	

RELEASED
04.02.03

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

41

DART AEROSPACE LTD		Work Order:	21241
Description: Basket Lid Assembly		Part Number:	D3267-041
			D3267-043
Drawing: D3267 Rev A		Qty:	1
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Open Traveler Dwg not required	AD	04.07.13	1
2	WS	Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267 Batch: <u>M15360</u> <u>M15713</u> Cut Qty 4 D2236-1 from: Qty 1 D3166-3 Batch: <u>B22086</u> Note: D3166-3 included in D3267-041 BOM	PD	05-01-14	1
3	WS	Drill holes in tubing D3267-041 as per Dwg D3267	PD	05-01-17	1
4	WS	Deburr	PD	05-01-17	1
5	WS	Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required Pick: Only apply for D3267-041 BOM. Qty Part number Description Batch 2 D2327-3 Bushing <u>B21546</u> 1 D2506 Label Plate <u>B22162A</u> 2 D2581 Mounting Brackets <u>B21503</u> 7.8sf M304EX0.75-16F Expanded Metal <u>M16343</u> <u>M16294</u> Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.	PD	05-01-18	1
6	WS	Drill Ø0.257" hole in D3267-041 as per Dwg D3267 Identify as D3267-041 <u>DRILL 1" OVER, 12 29.38 406.01.18</u>	PD	05-01-18	1
7	WS	Drill holes in tubing D3267-043 as per Dwg D3267	PD	05-01-18	1
8	WS	Deburr	PD	05-01-18	1
9	WS	Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required. Pick: Only apply for D3267-043 BOM. Qty Part number Description Batch 2 D3182-1 Hinge <u>B20706</u> 4.3sf M304EX0.75-16F Expanded Metal <u>M16343</u> <u>M16294</u> Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid. Identify as D3267-043	PD	05-01-24	1
10	QC9/6	Inspect D3267-041/-043 Weld and Dimensions	PD	05/01/24	1
11	FP	Powder Coat White (Ref. 4.3.5.2) D3267-041/-043 as per QSI 005 4.3 & Dwg D3267	MM	05/01/31	1
12	FP	Wing walk D3267-041 only as per Dwg D3267 and QSI 005 4.4 Spray Paint Black: <u>M16479</u> Wing Walk: <u>M16266</u>	MM	05/01/31	1
13	QC3	Inspect Powder Coat and Wing Walk	SB	05/02/01	1
14	FP	To GA Cell for Assembly	SB	05/02/01	1

Rev	Date	Change	Revised By	Approved
A	04.04.07	New Issue	KJ/RF	

RELEASED
04.04.08

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
05.01.18	6	DRILL MIDDLE $\phi 0.257$ hole 1" over to clear base rib. Drill @ 29.39" PERMANENT CHANGE	PD	05-01-18	1	UP 05.01.18	05.02.08

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____